

Work Order ID 79687 -2.

Tuesday, January 31, 2012 2:25:07 PM

79687

Page 1

Item ID: D3859-041

Revision ID:

Item Name: Wearplate

Start Date: 1/31/2012 Start Qty: 5.00

Required Date: 2/3/2012 Req'd Qty: 5.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: *MX*

Date: *12-01-31* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3859

REV A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3859 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

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Page 2

Item ID: D3859-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Wearplate

Stop

NS2

Start Date: 1/31/2012 Start Qty: 5.00

5

Required Date: 2/3/2012 Req'd Qty: 5.00

5

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod
Batch: M114509 2-Weld hard facing as per Dwg D3859 A/R
2059B Hard Coat rod Batch: M120892 *****use
DT9462 for welding*****

7

12-03-13/PL

140

140

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PL 12-03-13

FX Ø

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S. 2/6/13

72

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Item ID: D3859-041

Revision ID:

Item Name: Wearplate

Start Date: 1/31/2012 Start Qty: 5.00

Required Date: 2/3/2012 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start

Stop

NS1

NS2

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NR1

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

0.00

START TIME: 10h05

OVEN TEMPERATURE:

10h35 FINISH TIME:

320°F

m118 489.

7

12/13/15

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

12/13/15

(Z)

180

Identify as per dwg & Stock Location:

0.00

180

Packaging

Packaging

Memo

0.00

st
su

12/13/16 (7)

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Page 4

Item ID: D3859-041

Revision ID:

Item Name: Wearplate

Start Date: 1/31/2012 Start Qty: 5.00

Required Date: 2/3/2012 Req'd Qty: 5.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/3/20 JJ

11-03-20

Picklist Print

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Page 1

Work Order ID: 79687
Parent Item: D3859-041
Parent Item Name: Wearplate

Start Date: 1/31/2012
Start Qty: 5.00

Required Date: 2/3/2012
Required Qty: 5.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA
304/316 Sheet .063

Purchased No

100 sf 71.5000 0.85 4.25

Location:

Loc Qty

Loc Code

MAT020

71.5

119653

17.03

120243

54.47

D3009-3
Cup

Manufactured No

130 Each 40.0000 6 30

Location

Loc Qty

Loc Code

WA

40

79078 XI

40

80095 X 41

12-03-03 gbl

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

2059B HARDCOAT
10 PL

0.06
TO
0.13
HIGH

Q
SYM

0.38

1.0
TYP

3.1
TYP

1.50
REF

1.00

HARDCOAT WELD
SURFACING
REF

6 PL
1/32

6

D3859-1 WEARPLATE (1)

INSTALL D3009-3 FLUSH
WITH THIS SURFACE
TYP

D3009-3 CUP (6)

D3859-041 WEARPLATE

RELEASED
09 01.26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3859	REV. A
TITLE WEARPLATE	SHEET 1 OF 2
SCALE NTS	
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